

5/42

DART AEROSPACE LTD	Work Order:	24367
Description: Ø3.250 Support	Part Number:	D2940-1
Dwg: D2940 Rev. A1	Qty:	20
		Page 1 of 1

RF
03.06.09

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller. Blank size makes (2) D2940-1 Dwg not required	CH	05.09.29	20
2	PG	Issue P/O: 200877 Description: D6104-007 Material: 17-4 PH SS (AMS 5643 OR AISI 630) as per Dwg D6104 Material release note required.	SH	05/09/20	20
3	RG	Receive and Inspect for raw material dimensions. Ensure material release note is attached.	CH	05/10/07	20
4	MS	Turn blank for Haas as per Folio FA079	3.9/05	05/10/07	20
5	QC1	Inspect all dimensions as per Dwg D2940	3.9/05	05/11/07	20
6	MV	Machine as per Folio FA079	JL	05.12.01	19
7	MV	Tumble & Deburr	JL	05.12.01	19
8	QC1	Inspect all dimensions to inspection sheet as per Dwg D2940	JL	05.12.01	19
9	QC8	Inspect dimensions for second check	CH	05/12/01	19
10	FP	Powder Coat White (4.3.5.2) per QSI 005 4.3	a.m.	06/02/11	20
11	QC3	Inspect Powder Coat	CH	06/02/13	20
12	ST	Identify and stock	CH	06/02/13	38
13	AC	Cost / part	5.1/06	06.02.14	38
14	DC	Close W/O Inspect Level 21	CH	06/02/14	38

Rev	Date	Change	Revised By	Approved
A	01.01.08.	Preliminary Issue	EC	
B	01.08.15	Removed Heat treating	EC	
C	02.11.26	Reformat; Added P/O	KJ / RF RF	CH

RELEASED
02/11/29 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 24367		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.11.01	4	One blank cut too short, length = 4.936"	QP	PART IS OK.	JWL 05.11.10	2 05.11.01	QP 05.11.02 per QSI 042	2 05.11.01
05.11.14	6	- 1 part scrap - set set up problems	QP	Scrap - No Replace Fix settings on CNC destroy	J.L 05.11.13	2 05.11.14	QP 05.12.14 per QSI 042	2 05.11.14
05.11.21	6	"A" dimension .3 .146" / should be .160 ± .010"	QP	Fix "A" axis runout. PART IS OK with 0.146" dim is OK for this one	SD 05.11.21	2 06.02.14	QP 05.11.24 per QSI 042	2 06.02.14

Part No: D2940-1

PAR #: N/A

Fault Category: Prod / Machine / Parts

NCR:

Yes

No

DQA:

Date:

NOTE: Date & initial all entries

QA: N/C Closed:

Date:

DART AEROSPACE LTD

Work Order: 24367

Description: Ø3.250 Support

Part Number: D2940-1

Inspection Dwg: D2940 Rev. A1

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. A1/ DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	3.211	3.216		3.213	3.216	3.216	3.216		
B	4.946	4.966		4.957	4.946	4.957	4.958		
C	0.718	0.738		.721	.734	.721	.734		
D	0.090	0.110		.100	.099	.091	.098		
E	3.564	3.584		3.565	3.576	3.575	3.576		
F	0.022	0.042		.032	.032	.032	.032		
G	3.444	3.464		3.445	3.455	3.456	3.456		
H	0.112	0.132		.116	.117	.117	.118		
I	2.170	2.190		2.178	2.172	2.175	2.176		
J	4.451	4.471		4.451	4.461	4.461	4.461		
K	0.413	0.433		.413	.417	.425	.425		
L	0.913	0.933		.922	.914	.930	.930		
M				E.D	M.L	M.L	M.L		
N									
HAAS Section									
AA	0.240	0.260		.250	.250	.250	.250		
AB	0.490	0.510		.500	.500	.500	.500		
AC	0.140	0.160		.149	.151	.146	.151		
AD	3.510	3.530		3.514	3.515	3.513	3.517		
AE	1.633	1.673		1.656	1.656	1.655	1.656		
AF	1.493	1.513		1.506	1.510	1.511	1.506		
AG	0.040	0.060		.053	.058	.054	.053		
AH	0.188	0.193	DT8706	.188	.189	.188	.189		
AI	0.140	0.160		.150	.150	.153	.150		
AJ	2.518	2.538		2.530	2.525	2.532	2.532		
AK	0.040	0.060		.047	.047	.045	.051		
AL	0.010	0.020		.010	.010	.010	.010		
AM	0.140	0.160		.150	.149	.151	.152		
AN	0.350	0.450		.380	.378	.367	.390		
AO	0.240	0.260		.250	.250	.250	.250		
AP	0.150	0.170		.155	.151	.146	.153		
AQ	0.053	0.073		.063	.063	.063	.063		
AR	101.64	105.64	DT8698						
AS	0.257	0.262	DT8683	.257	.257	.259	.258		
AT	0.053	0.073		.063	.063	.063	.063		
AU	4.118	4.138		4.128	4.127	4.137	4.137		
AV									
AW									
Accept/Reject									

Measured by: S-D / JL

Date: 05.11.21 / 05.11.22

Audited by: gmc

Date: 05.12.01

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	

RELEASED
03.07.01 RF

JOINT AEROSPACE LTD
Work Order: 24367

Description: Ø3.250 Support

Part Number: D2940-1

Inspection Dwg: D2940 Rev. A1

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. A1/ DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	3.211	3.216		3.216	3.216	3.215	3.216	M.L	05/10/30
B	4.946	4.966		4.958	4.962	4.960	4.957		
C	0.718	0.738		.726	.730	.731	.728		
D	0.090	0.110		.100	.096	.096	.100		
E	3.564	3.584		3.576	3.580	3.580	3.580		
F	0.022	0.042		.032	.032	.032	.032		
G	3.444	3.464		3.455	3.454	3.454	3.455		
H	0.112	0.132		.119	.118	.118	.119		
I	2.170	2.190		2.178	2.176	2.177	2.176		
J	4.451	4.471		4.461	4.463	4.465	4.462		
K	0.413	0.433		.420	.418	.420	.418		
L	0.913	0.933		.928	.930	.928	.927		
M									
N									
HAAS Section									
AA	0.240	0.260		.250	.250	.250	.250		
AB	0.490	0.510		.500	.500	.500	.500		
AC	0.140	0.160		.153	.151	.152	.151		
AD	3.510	3.530		3.517	3.517	3.516	3.517		
AE	1.633	1.673		1.640	1.656	1.654	1.654		
AF	1.493	1.513		1.493	1.504	1.504	1.505		
AG	0.040	0.060		.054	.052	.055	.055		
AH	0.188	0.193	DT8706	.190	.190	.190	.190		
AI	0.140	0.160		.152	.152	.155	.153		
AJ	2.518	2.538		2.530	2.529	2.530	2.528		
AK	0.040	0.060		.050	.050	.049	.049		
AL	0.010	0.020		.010	.010	.010	.010		
AM	0.140	0.160		.151	.149	.151	.151		
AN	0.350	0.450		.380	.380	.385	.380		
AO	0.240	0.260		.250	.250	.250	.250		
AP	0.150	0.170		.151	.151	.152	.150		
AQ	0.053	0.073		.063	.063	.063	.063		
AR	101.64	105.64	DT8698						
AS	0.257	0.262	DT8683	.257	.257	.257	.257		
AT	0.053	0.073		.063	.063	.063	.063		
AU	4.118	4.138		4.135	4.135	4.135	4.135		
AV									
AW									
Accept/Reject									

 Measured by: J.L.
 Date: 05.11.24

 Audited by: JML
 Date: 05/12/01

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	

 RELEASED
 03.07.01 RF

DART AEROSPACE LTD		Work Order:	24367
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940 Rev. A1		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. A1/ DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	3.211	3.216		3.216"	3.212"	3.215"	3.214"	MS	05/10/31
B	4.946	4.966		4.958"	4.955"	4.955"	4.955"		
C	0.718	0.738		.729"	.728"	.725"	.726"		
D	0.090	0.110		.098"	.101"	.101"	.101"		
E	3.564	3.584		3.578"	3.576"	3.575"	3.575"		
F	0.022	0.042		.032"	.032"	.032"	.032"		
G	3.444	3.464		3.457"	3.462"	3.455"	3.454"		
H	0.112	0.132		.119"	.121"	.119"	.120"		
I	2.170	2.190		2.178"	2.177"	2.178"	2.174"		
J	4.451	4.471		4.461"	4.463"	4.461"	4.460"		
K	0.413	0.433		.417"	.419"	.416"	.415"		
L	0.913	0.933		.925"	.925"	.925"	.925"		
M									
N									
HAAS Section									
AA	0.240	0.260		.250	.250	.250	.250		
AB	0.490	0.510		.500	.500	.500	.500		
AC	0.140	0.160		.154	.154	.154	.153		
AD	3.510	3.530		3.530	3.526	3.530	3.526		
AE	1.633	1.673		1.665	1.664	1.669	1.659		
AF	1.493	1.513		1.508	1.503	1.509	1.505		
AG	0.040	0.060		.056	.059	.056	.057		
AH	0.188	0.193	DT8706	.190	.190	.190	.190		
AI	0.140	0.160		.153	.154	.151	.152		
AJ	2.518	2.538		2.535	2.530	2.535	2.535		
AK	0.040	0.060		.048	.050	.048	.051		
AL	0.010	0.020		.010	.010	.010	.010		
AM	0.140	0.160		.151	.153	.148	.152		
AN	0.350	0.450		.380	.380	.380	.380		
AO	0.240	0.260		.250	.250	.250	.250		
AP	0.150	0.170		.164	.160	.160	.152		
AQ	0.053	0.073		.063	.063	.063	.063		
AR	101.64	105.64	DT8698						
AS	0.257	0.262	DT8683	.258	.258	.258	.258		
AT	0.053	0.073		.063	.063	.063	.063		
AU	4.118	4.138		4.136	4.135	4.137	4.136		
AV									
AW									
Accept/Reject									

Measured by:	JL
Date:	05.11.24

Audited by:	mf
Date:	05/12/01

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	RF

15.5	1	15.5	1
15.5	2	15.5	2
15.5	3	15.5	3
15.5	4	15.5	4
15.5	5	15.5	5
15.5	6	15.5	6
15.5	7	15.5	7
15.5	8	15.5	8
15.5	9	15.5	9
15.5	10	15.5	10
15.5	11	15.5	11
15.5	12	15.5	12
15.5	13	15.5	13
15.5	14	15.5	14
15.5	15	15.5	15
15.5	16	15.5	16
15.5	17	15.5	17
15.5	18	15.5	18
15.5	19	15.5	19
15.5	20	15.5	20
15.5	21	15.5	21
15.5	22	15.5	22
15.5	23	15.5	23
15.5	24	15.5	24
15.5	25	15.5	25
15.5	26	15.5	26
15.5	27	15.5	27
15.5	28	15.5	28
15.5	29	15.5	29
15.5	30	15.5	30
15.5	31	15.5	31
15.5	32	15.5	32
15.5	33	15.5	33
15.5	34	15.5	34
15.5	35	15.5	35
15.5	36	15.5	36
15.5	37	15.5	37
15.5	38	15.5	38
15.5	39	15.5	39
15.5	40	15.5	40
15.5	41	15.5	41
15.5	42	15.5	42
15.5	43	15.5	43
15.5	44	15.5	44
15.5	45	15.5	45
15.5	46	15.5	46
15.5	47	15.5	47
15.5	48	15.5	48
15.5	49	15.5	49
15.5	50	15.5	50
15.5	51	15.5	51
15.5	52	15.5	52
15.5	53	15.5	53
15.5	54	15.5	54
15.5	55	15.5	55
15.5	56	15.5	56
15.5	57	15.5	57
15.5	58	15.5	58
15.5	59	15.5	59
15.5	60	15.5	60
15.5	61	15.5	61
15.5	62	15.5	62
15.5	63	15.5	63
15.5	64	15.5	64
15.5	65	15.5	65
15.5	66	15.5	66
15.5	67	15.5	67
15.5	68	15.5	68
15.5	69	15.5	69
15.5	70	15.5	70
15.5	71	15.5	71
15.5	72	15.5	72
15.5	73	15.5	73
15.5	74	15.5	74
15.5	75	15.5	75
15.5	76	15.5	76
15.5	77	15.5	77
15.5	78	15.5	78
15.5	79	15.5	79
15.5	80	15.5	80
15.5	81	15.5	81
15.5	82	15.5	82
15.5	83	15.5	83
15.5	84	15.5	84
15.5	85	15.5	85
15.5	86	15.5	86
15.5	87	15.5	87
15.5	88	15.5	88
15.5	89	15.5	89
15.5	90	15.5	90
15.5	91	15.5	91
15.5	92	15.5	92
15.5	93	15.5	93
15.5	94	15.5	94
15.5	95	15.5	95
15.5	96		

DART AEROSPACE LTD

Work Order:

24367

Description: Ø3.250 Support

Part Number:

D2940-1

Inspection Dwg: D2940 Rev. A1

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. A1/ DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	13	14	15	16	By	Date
Lathe Section									
A	3.211	3.216		3.216	3.215	3.215	3.216	M8	
B	4.946	4.966		4.958	4.954	4.956	4.952		
C	0.718	0.738		0.728	0.730	0.728	0.730		
D	0.090	0.110		0.093	0.091	0.092	0.102		
E	3.564	3.584		3.574	3.573	3.574	3.574		
F	0.022	0.042		0.032	0.032	0.032	0.032		
G	3.444	3.464		3.448	3.449	3.449	3.448		
H	0.112	0.132		0.120	0.121	0.122	0.122		
I	2.170	2.190		2.174	2.180	2.175	2.174		
J	4.451	4.471		4.459	4.460	4.459	4.458		
K	0.413	0.433		0.414	0.413	0.414	0.415		
L	0.913	0.933		0.927	0.925	0.923	0.931		
M									
N									
HAAS Section									
AA	0.240	0.260		.250	.250	.250	.250		
AB	0.490	0.510		.500	.500	.500	.500		
AC	0.140	0.160		.155	.155	.153	.151		
AD	3.510	3.530		3.525	3.525	3.528	3.527		
AE	1.633	1.673		1.660	1.660	1.667	1.665		
AF	1.493	1.513		1.505	1.504	1.508	1.510		
AG	0.040	0.060		.059	.052	.049	.053		
AH	0.188	0.193	DT8706	.190	.190	.190	.190		
AI	0.140	0.160		.153	.153	.151	.149		
AJ	2.518	2.538		2.535	2.535	2.535	2.535		
AK	0.040	0.060		.052	.049	.049	.050		
AL	0.010	0.020		.010	.010	.010	.010		
AM	0.140	0.160		.150	.149	.151	.151		
AN	0.350	0.450		.370	.375	.373	.373		
AO	0.240	0.260		.250	.250	.250	.250		
AP	0.150	0.170		.154	.155	.159	.155		
AQ	0.053	0.073		.063	.063	.063	.063		
AR	101.64	105.64	DT8698						
AS	0.257	0.262	DT8683	.259	.259	.259	.259		
AT	0.053	0.073		.063	.063	.063	.063		
AU	4.118	4.138		4.135	4.137	4.137	4.137		
AV									
AW									
Accept/Reject									

Measured by:

S.G. / J.L. / S.A.

Date:

05/11/02

Audited by:

J.M.

Date:

05/12/01

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	

 RELEASED
03.07.01 RF

20110902

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743

750 750 750

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C.

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Figure 2

(Faint handwritten notes or markings)

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DART AEROSPACE LTD		Work Order: 24367
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940 Rev. A1		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. A1/ DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1 17	2 18	3 19	4 20	By	Date
Lathe Section									
A	3.211	3.216		3.213	3.215	3.215	3.216		
B	4.946	4.966		4.950	4.952	4.955	4.954		
C	0.718	0.738		0.730	0.731	0.725	0.728		
D	0.090	0.110		0.100	0.098	0.093	0.101		
E	3.564	3.584		3.575	3.575	3.576	3.575		
F	0.022	0.042		0.032	0.032	0.032	0.032		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		0.121	0.121	0.119	0.118		
I	2.170	2.190		2.170	2.170	2.171	2.170		
J	4.451	4.471		4.459	4.459	4.458	4.459		
K	0.413	0.433		0.414	0.415	0.413	0.415		
L	0.913	0.933		0.932	0.931	0.932	0.930		
M									
N									
HAAS Section									
AA	0.240	0.260		.250	.250	.250			
AB	0.490	0.510		.500	.500	.500			
AC	0.140	0.160		.151	.153	.153			
AD	3.510	3.530		3.528	3.528	3.529			
AE	1.633	1.673		1.665	1.666	1.664			
AF	1.493	1.513		1.503	1.503	1.506			
AG	0.040	0.060		.046	.046	.049			
AH	0.188	0.193	DT8706	.190	.190	.190			
AI	0.140	0.160		.151	.151	.151			
AJ	2.518	2.538		2.533	2.532	2.540			
AK	0.040	0.060		.047	.050	.046			
AL	0.010	0.020		.01	.01	.01			
AM	0.140	0.160		.152	.154	.164			
AN	0.350	0.450		.370	.368	.373			
AO	0.240	0.260		.250	.250	.250			
AP	0.150	0.170		.162	.162	.160			
AQ	0.053	0.073		.063	.063	.063			
AR	101.64	105.64	DT8698						
AS	0.257	0.262	DT8683	.258	.258	.258			
AT	0.053	0.073		.063	.063	.063			
AU	4.118	4.138		4.136	4.137	4.130			
AV									
AW									
Accept/Reject									

Measured by:	S. G / SA
Date:	05/11/02

Audited by:	gml
Date:	05/12/01

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 28, 2005
03:40 pm

Work Order No : 0024367
Project Name : D2940-1
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : D2940-1
Description : Support
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 09-28-05
Est Finish Date : 10-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

**VALBRUNA**

SLATER STAINLESS, INC.
2400 Taylor Street West, P.O. Box 630
Fort Wayne, Indiana USA 46801
Phone: 260-434-2892 Fax: 260-434-2905

Product Certification Report**Report Number: 4045940**

Certified on Feb 16, 2005 Page 1 of 1

Order I.D. 0500061 001		Order Date 1/06/05		Commodity Code	
Dim 1 4.5000	Dim 2 .0000	Dim 3 .0000	Heat I.D. 415206	Customer I.D. 001145	Customer Purchase Order CB8757
Product Shape Rounds			Product Surface HR & Rough Turned		Customer Grade 17-4
Length (Inches) 132.000 Min. 156.000 Max.			Bill of Lading # 400800	Weight	

Ship To

COPPER AND BRASS SALES
6555 E DAVISON
DETROIT, MI 48212

Sold To

VALBRUNA CORP.
31 IRON HORSE ROAD
OAKLAND, NJ 07436

Lifts: 0046 0047**ASTM 630****CONDITION A****ASTMA 564-02****ASMESA 564 01 ED 2002 ADD****AMS 2303E****AMS 5643Q****CHEMICAL ANALYSIS**

C	Mn	P	S	Si	Cr	Ni	Mo	Cu	N	Cb	Ta	Cb+Ta
.036	.54	.025	.025	.37	15.55	4.67	.23	3.32	.04	.30	.001	.30

HB**352****TENSILE PROPERTIES****CAPABILITY**

HB	TS (PSI)	.2%YS (PSI)	%EL(2")	%RA	AGE(F)
444	207000	181400	14.3	48.4	900

MAGNETIC PARTICLE TEST**FREQ SEV****AVG .00 .00****MACRO ASTM E340/E381****MACRO****OK****OK****OK****PERCENT FERRITE****% FERRITE****AVG 1.0****Free of mercury and low melting alloy contamination.****Maxx stainless.****Chemical testing performed to one or several of the following ASTM methods: E415, E572, E1019, E1085, E1086.****Material melted in Italy, manufactured in the United States.****Material conforms to listed specifications.****Quality system is compliant with ISO 9001:2000. Produced in accordance with EN 10204 3.1B.**

Date	<u>10-5-05</u>
Cust	<u>DIRT HEPASPHCE</u>
W/O #	<u>163126</u>
Qty	<u>465</u> Pcs.
<input checked="" type="checkbox"/> Size	<input type="checkbox"/> Special Instructions
<input checked="" type="checkbox"/> Part #	<input checked="" type="checkbox"/> Alloy <input checked="" type="checkbox"/> Heat/Lot
These test reports are for material shipped on your PO# <u>UW3658</u>	
From <u>Copper & Brass Sales</u>	
Quality Representative <u>MS Cidm</u>	
<u>11-11-05 AH Receipt</u>	
Customer Part #	

Results relate only to the items tested. Certification shall not be reproduced except in full, without written approval of Valbruna Stainless Inc. The recording of false, fictitious, or fraudulent statements on this document may be punished as a felony under federal statutes, including Federal law, Title 18, Chapter 47. Consult material safety data sheet (MSDS) for hazard info. I hereby certify that the reported figures are correct as contained in the records of the corporation.

Manager Laboratory Services

Dennis Hackett

Chris Provencal

From: David Shepherd [davids@dartaero.com]
Sent: November 1, 2005 6:42 PM
To: Chris Provencal
Subject: Re: machined deviations

Both of the deviations below are acceptable to me.

David

----- Original Message -----

From: "Chris Provencal" <cprovencal@dartaero.com>
To: <davids@dartaero.com>
Sent: Tuesday, November 01, 2005 11:58 AM
Subject: machined deviations

> D2940-1 Support (that's the 3.250 OD xtube support): one blank was cut too short. This essentially makes one of the tabs that hold the hose clamps > about 0.070" instead of 0.100". The part looks good to me since everything > else is OK and there is still plenty of tab to prevent the hose clamp from > shearing through it.
>
> D3196-1 Bar (the center rectangular bar for the shoulder harness): For one > piece, the countersinks are 0.760 OD" instead of 0.660" OD.
>
> Sincerely,
> Chris Provencal
> DART Aerospace Ltd.
> Email..cprovencal@dartaero.com
> Phone....613-632-3336
> Fax.....613-632-4443
>
>

Chris Provencal

From: David Shepherd [davids@dartaero.com]
Sent: November 22, 2005 3:23 PM
To: Chris Provencal
Subject: Re: ncrs

Chris,

With respect to the D3121-11, please review the stress report SR-D412-698-1 (I think) to get a feel for how much margin exists. Note that loads are based on regular doors not Spacedoors, so loads might go up a bit.

With respect to the D2940-1, I agree that 0.146" instead of 0.160" is acceptable.

David

----- Original Message -----

From: "Chris Provencal" <cprovencal@dartaero.com>
To: <davids@dartaero.com>
Sent: Tuesday, November 22, 2005 8:36 AM
Subject: ncrs




> Dave,
>
> One D3121-11 roller bracket. The base is 0.010" under tolerance in
> thickness. Other dimensions are OK. Is this acceptable. Looks good to
me.
>
> One D2940-1 bracket, the height of the verticle flange from the round
> surface should be 0.160", it is 0.146" instead. Picture attached showing
> what dimension. Other dims are OK.
>
> Sincerely,
> Chris Provencal
> DART Aerospace Ltd.
> Email..cprovencal@dartaero.com
> Phone...613-632-3336
> Fax.....613-632-4443
>
>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05.12.01	6	Dimension 2.528" on dwg is 2.540" on on part		Part is OK	 05.12.01		 05.12.01	

NOTE: Date & initial all entries